

Date: Tuesday, 4/4/2006 1:27:16 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 26492		
Estimate Number	: 10441		
P.O. Number	: N/A	Part Number	: D32621
This Issue	: 4/4/2006	Drawing Number	: D3262 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 26453	Material	: N/A
Written By	:	Due Date	: 4/30/2006
Checked & Approved By	: <u>KJL</u> 06.04.04	Qty:	6
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T5000W125	6061-T6 Tube 5.00X.125W 	
Comment: Qty.: 0.9406 f(s)/Unit Total : 3.7624 f(s) Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: <u>M17002</u>			
2.0	BAND SAW	BAND SAW 	
Comment: BAND SAW Cut D3262-1 to length as per Dwg D3262 Identify as D3262-1			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK 	
Comment: SECOND CHECK			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ○ No ○ DQA: Date: 06/17/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 26492

Part Number: D32621

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WAB*

PK. 06-11-7

6

7.0	DC	DOCUMENT CONTROL
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(6)

Comment: DOCUMENT CONTROL

Inspection Level 21

doc 11,108

Job Completion



U 06.11.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

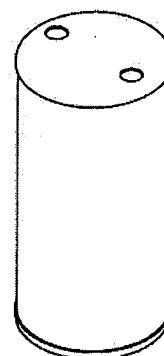
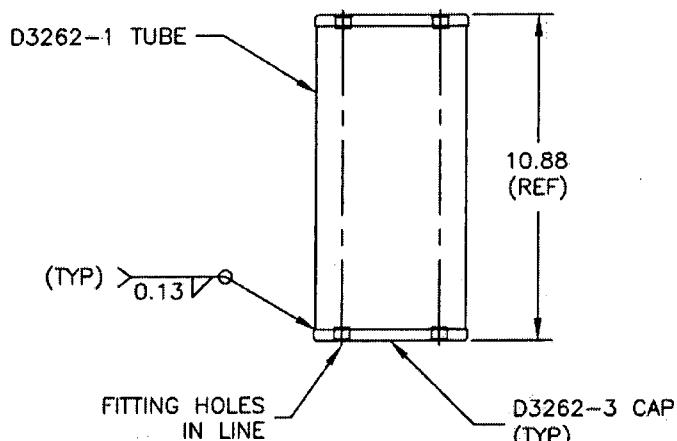
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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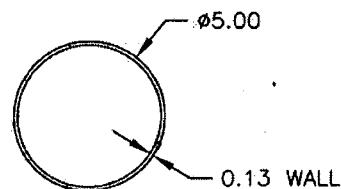
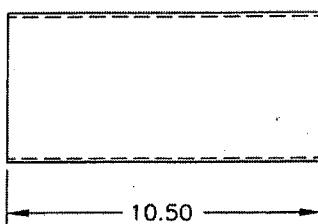
NOTE: Date & initial all entries

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

RELEASED
05.02.14 *[initials]*

D3262-041 CANISTER ASSEMBLY



D3262-1 TUBE

D3262-041:

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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SUBJECT TO AMENDMENT

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WORK ORDER

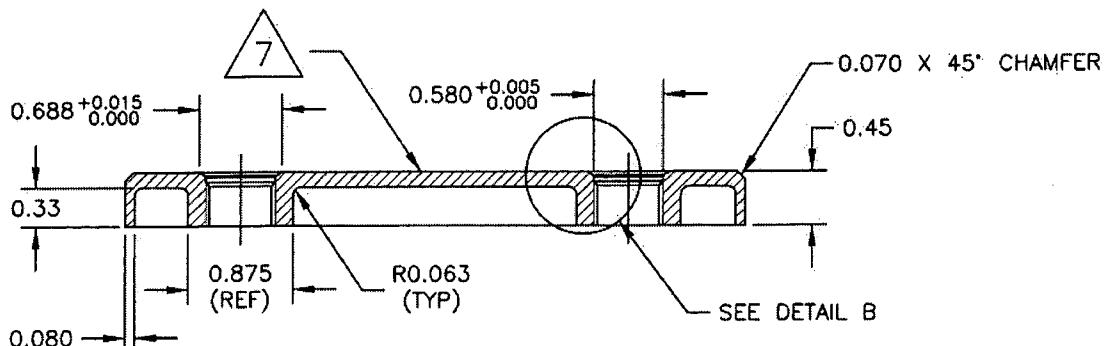
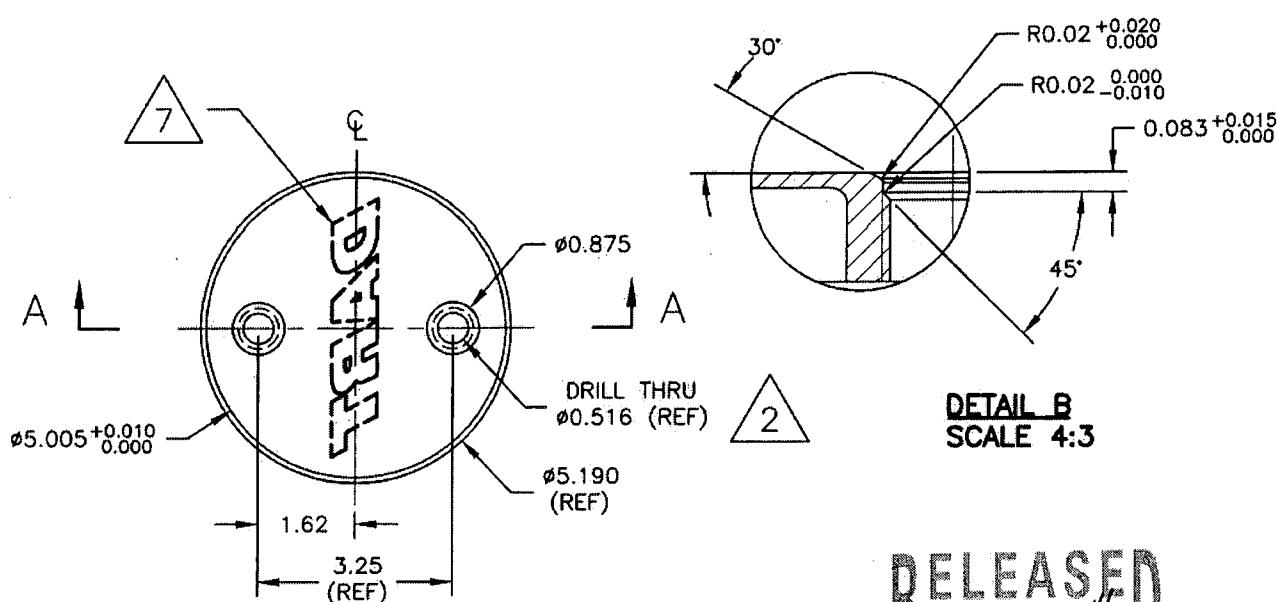
NO. 26492

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DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MF</i>	APPROVED <i>MF</i>	DRAWING NO. D3262 REV. B SHEET 2 OF 2
DATE 05.02.14	TITLE FUEL PURGE CANISTER	SCALE 1:3

**SECTION A-A**
SCALE 2:3**DETAIL B**
SCALE 4:3**D3262-3 CAP****RELEASED**
05.02.14 *[Signature]***D3262-3**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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WORK ORDER
NO. 26492

DAR, AEROSPACE LTD

Work Order:

26492

~~TUBE FUEL PURGE CANISTER~~

Part Number:

D 3262-1

Indicates 5-91 A3262

Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Digitized by srujanika@gmail.com

SD

Audited by:

86

27

06.05.08

Date:

06.05.08

Prototype Approval:

Date:

11A

- 10 -

Editorial Staff

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Revised by
KURE

Approved

QAFQAF revD, QAFQAF revE, QAFQAF revF, QAFQAF revG, QAFQAF revH